

Work Order ID 58644

May 12, 2010 1:49:48 PM

14/05



Page 1

Item ID: D3371-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Pedal Lock Assembly

Start Date: 5/12/10 Start Qty: 8.00



Cust Item ID:

Required Date: 5/14/10 Req'd Qty: 8.00

Customer:

Reference:

Run Start



Approvals: Process Plan: *W*

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3371

Rev B

120

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

1- Press dowel pins as per Dwg D3371, then assemble hinge. Ensure that assembly opens & closes smoothly. Identify as D3371-051.
2- Open D3373-7 lock package. Keep keys, lock body, lock body nut, straight cam, lock barrel, screw, 90° rotation washer and external tooth lock washer. Discard the rest.
3- Fabricate D3371-5 cam as per Dwg D3371. Identify as D3371-5
4- Assemble lock mechanism and cam and install decal as per Dwg D3371.
Apply locktite to lock body nut.

Qty	Part Number	Description	Batch
A/R		262 Locktite	

Batch

M110005

M-d w/05/17

Pho →

130

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

Assemble lanyard to cyclic sock as per Dwg D3384
Identify as D3384-045

=> M-d w/05/18

Dart Aerospace Ltd

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3371-041 PAR #: (1) Fault Category: machined parts / Finishing NCR: Yes No DQA: (2) Date: 10/05/14
 Resolution: rework Disposition: rework QA: N/C Closed Date: 10/05/18

NCR: <u>58644</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10/05/13	# 100	Dunkin Assembly Found Qty + 3 that have the .635" slot / hole too small (measure .617") on D3371-3 cover for use measure Dunkin	<u>OS1042</u>	re-work the hole in accordance to the drawing dimension. Touch-up with Alodine & paint per QSI 005.	<u>10/05/18</u>	<u>SP 10/05/18</u>	<u>OS1042</u>	<u>10/05/13</u>
		machin. RC: LOA	<u>OS1042</u>				<u>OS1042</u>	<u>10/05/13</u>
10/05/13	# 100	Found an assembly that A Bump inside the 1.200" Bore on D3371-3 cover. RC: not inspected correctly	<u>OS1042</u>	Too much powder coat inside the bore causing a huge run & build up of paint. Remove the paint from inside the bore & re-allocate & paint per QSI 005.	<u>SP 10/05/18</u>	<u>10/05/18</u>	<u>OS1042</u>	<u>10/05/13</u>

NOTE: Date & initial all entries

RC: LOA

Work Order ID 58644

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Item ID: D3371-041

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Setup Start

Revision ID:

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Item Name: Pedal Lock Assembly

Start Date: 5/12/10 Start Qty: 8.00



Cust Item ID:

Required Date: 5/14/10 Req'd Qty: 8.00



Customer:

Reference:

Run Start

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

140



Small Fab

Small Fab

Small Fab

Memo

0.00

- 1- Assemble D3384-045 to D3371-051 using 1/4"-20 socket head cap screw and washer as per Dwg D3371.
- 2- Identify as D3371-041 & attach keys
- 3- Record the Key Number on page 4

C420A

m. l 10/05/18

150



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

8/05/18

(XS)

160



Packaging

Packaging

Identify as per dwg & Stock Location: _____

0.00

Memo

0.00

10/05/18 (S)

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
Number Insp.
Stamp

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/05/18 *[Signature]*
ML
10-5-18

W/O:			WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

May 12, 2010 1:49:45 PM

Page 1

Work Order ID: 58644

Parent Item: D3371-041

Parent Item Name: Pedal Lock Assembly



Start Date: 5/12/10

Required Date: 5/14/10

Comments: IPP Rev: A Removed from 9 Digit 06-03-10 KJ

Start Qty: 8.00

Required Qty: 8.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
238-028  3/16" Dowel Pin .5" long		Purchased	No			120	Each	99.0000	2		5/10/05/13 M17878 (9x)	

Location

Loc Qty

Loc Code

ST399 92
106673 92
ST400 7
17278 7

AN526C832R6

Purchased

No

120 Each 402.0000 4



Screw

Location

Loc Qty

Loc Code

ST327 402
16612 402

AN960-416

Q-857017
NAS 1149 FO 463 M114223
Purchased No

140 Each 0.0000 2



Washer

CBL-1240

Purchased

No

130 Each 435.2688 1.6666



Cable

Location

Loc Qty

Loc Code

ST275 435.2688
113565 435.2688

13.327
A
10-5-18
5/10/05/13

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

Page 2

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Work Order ID: 58644

Parent Item: D3371-041

Parent Item Name: Pedal Lock Assembly






Comments: IPP Rev: A Removed from 9 Digit 06-03-10 KJ

Start Date: 5/12/10

Required Date: 5/14/10

Start Qty: 8.00

Required Qty: 8.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
CBL-460  Loop Sleeve		Purchased	No			130	Each	189.0000	2			
<div> <div>Location</div> <div>ST284</div> <div>114622</div> <div>ST285</div> <div>113002</div> </div> <div> <div>Loc Qty</div> <div>161</div> <div>161</div> <div>28</div> <div>28</div> </div> <div> <div>Loc Code</div> <div>A</div> <div>16</div> </div>												
D2728-7  Dart Logo label		Manufactured	No			120	Each	0.0000	0			
D3371-1  Pedal Lock Base		Manufactured	No			120	Each	1.0000	1			
<div> <div>Location</div> <div>ST485</div> <div>55349</div> </div> <div> <div>Loc Qty</div> <div>1</div> <div>1</div> </div> <div> <div>Loc Code</div> <div>1</div> </div>												
D3371-3  Pedal Lock Cover		Manufactured	No			120	Each	6.0000	1			
<div> <div>Location</div> <div>st493</div> <div>55461</div> </div> <div> <div>Loc Qty</div> <div>6</div> <div>6</div> </div> <div> <div>Loc Code</div> <div>1</div> </div>												
D3373-7  Cam Lock		Manufactured	No			120	Each	0.0000	1			

416435

May 12, 2010 1:49:45 PM

Shop Packet Print

Page 2

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

Picklist Print

Page 3

May 12, 2010 1:49:45 PM

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Parent Item Name: Pedal Lock Assembly

Comments: IPP Rev: A Removed from 9 Digit 06-03-10 KJ

Start Date: 5/12/10

Required Date: 5/14/10

Start Qty: 8.00

Required Qty: 8.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
D3384-1		Manufactured	No				Each	3.0000	1			



Cyclic Sock

D3384-041 already ass'd

Location	Loc Qty	Loc Code
ST486	3	
53632	1	
57798	2	

B 5 3472
B 5 8149

(4)
(9)



EP 10/05/13

D3385-3



Hinge

Manufactured No

Location	Loc Qty	Loc Code
ST054	125	
22387	125	

120 Each 125.0000



EP 10/05/13

HX-81



1/4"-20 SHCS 3/8" long

Purchased No

Location	Loc Qty	Loc Code
ST390	64	
110383	14	
114383	50	

140 Each 64.0000



EP 10/05/13

6
2

~~EP 10/05/13~~

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Shop Packet Print

Page 3

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

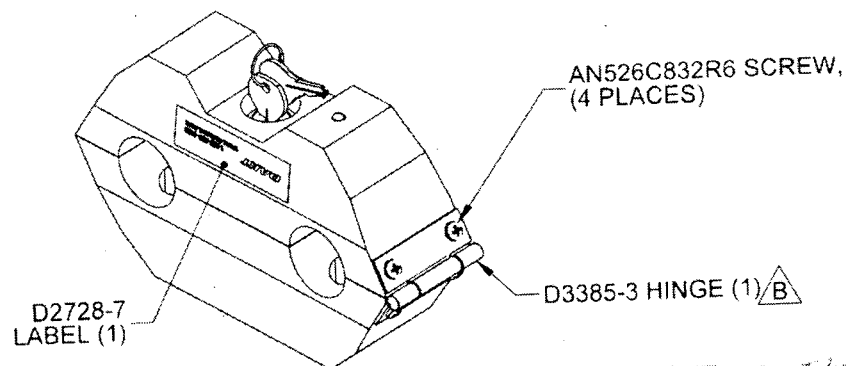
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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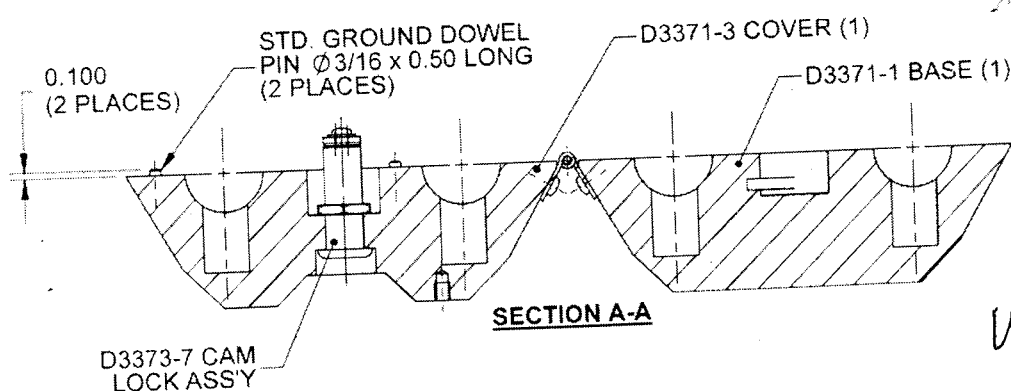
NOTE: Date & initial all entries



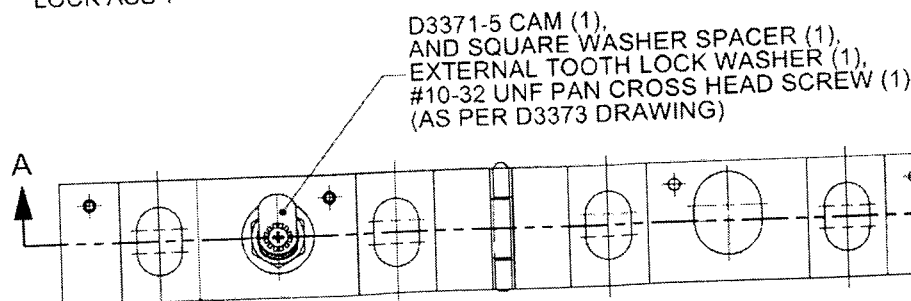
DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3371	REV. B SHEET 1 OF 4
DATE	05.03.22	TITLE PEDAL LOCK	SCALE 1:3
A	04.12.06	NEW ISSUE	
B	05.03.22	D3385-3 WAS D3385-1	



PEDAL LOCK SHOWN LOCKED WITH KEY



SECTION A-A



D3371-051 PEDAL LOCK ASSEMBLY

NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

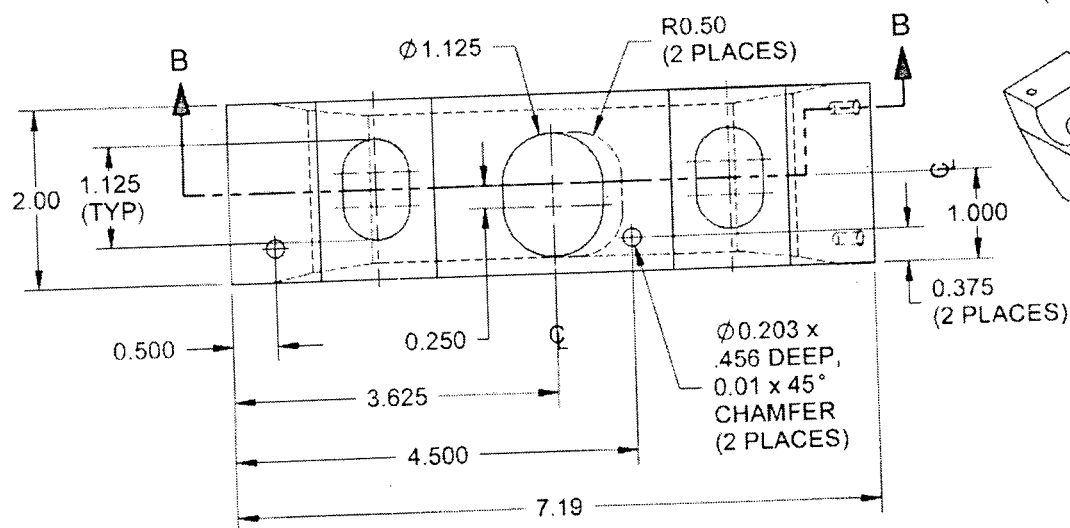
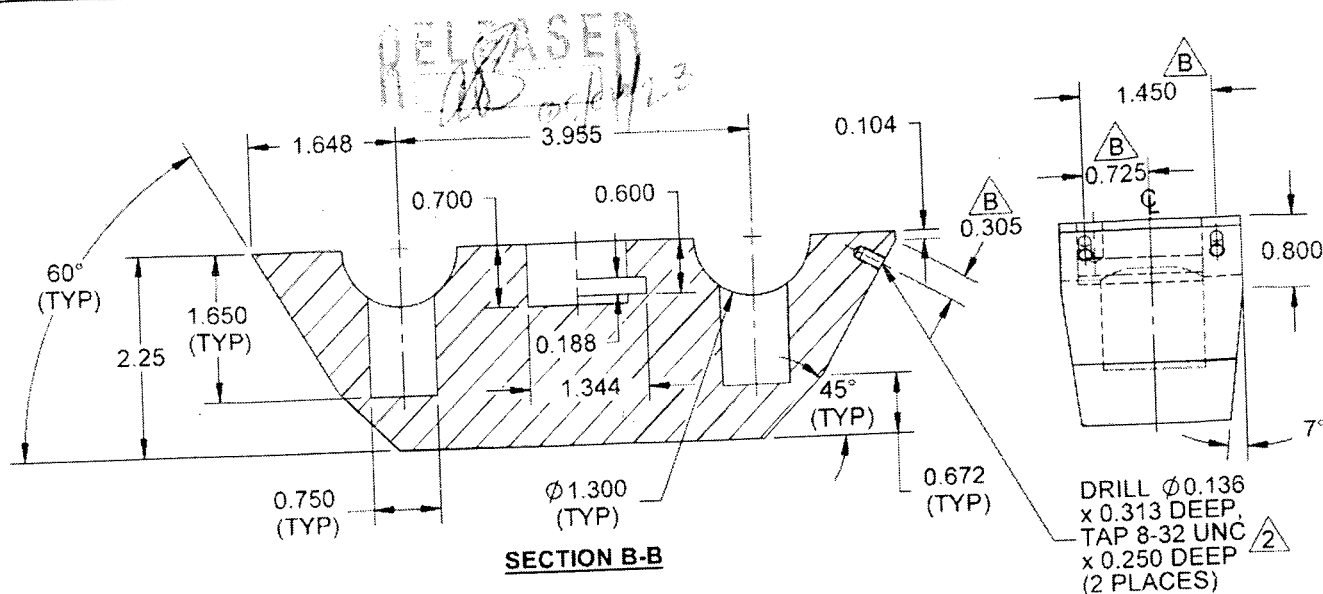
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3371	REV. B SHEET 2 OF 4
DATE 05.03.22		TITLE PEDAL LOCK	SCALE 1:2



D3371-1 BASE

NOTES:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC. M6061T6B)
- 2) COVER INSIDE HOLES PRIOR PAINTING
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

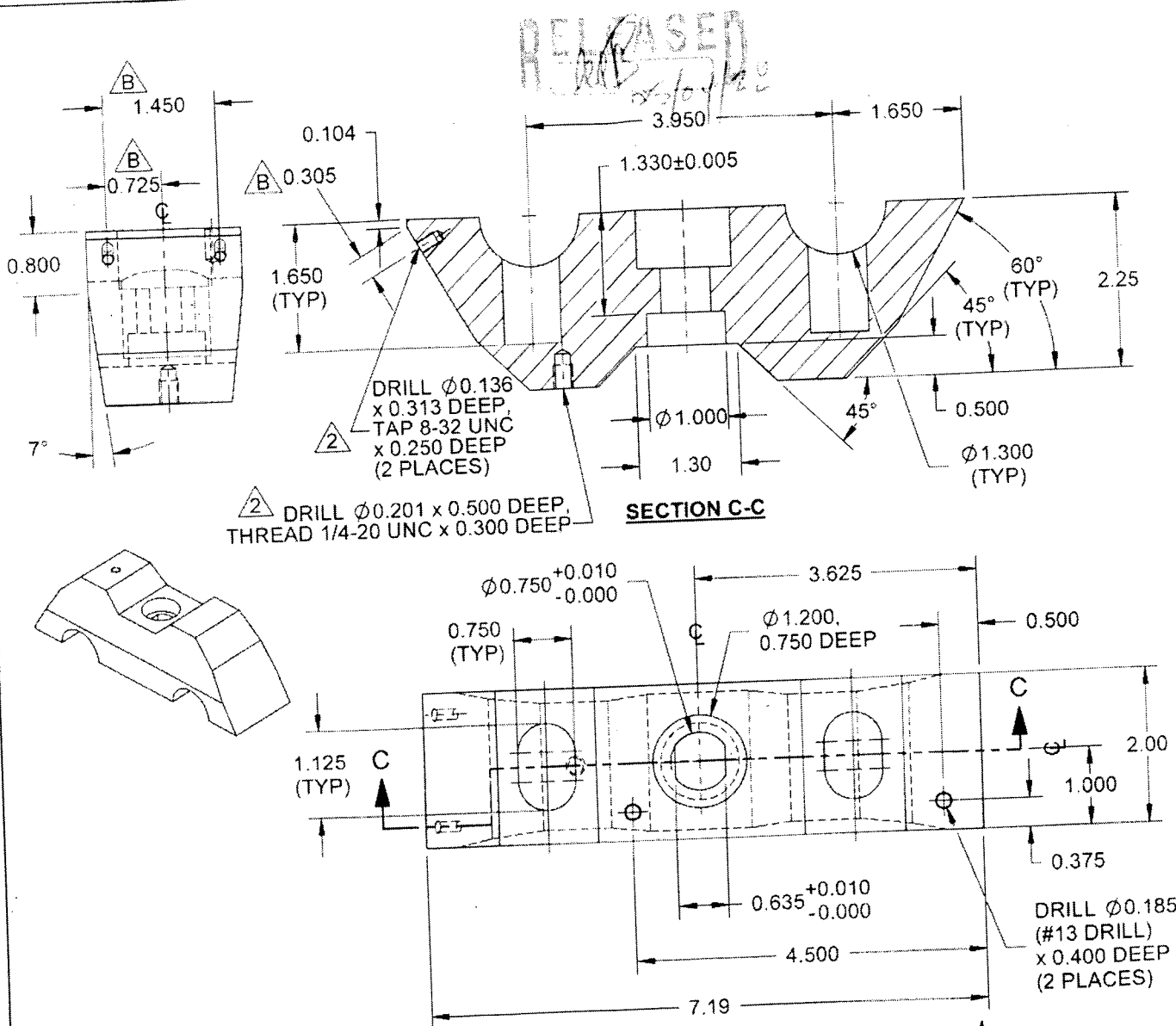
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3371	REV. B SHEET 3 OF 4
DATE 05.03.22	TITLE PEDAL LOCK		SCALE 1:2



NOTES:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC. M6061T6B)
- 2) COVER INSIDE HOLES PRIOR PAINTING
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
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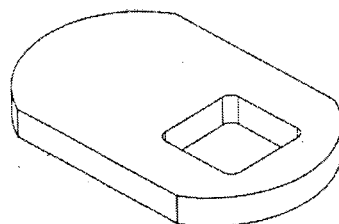
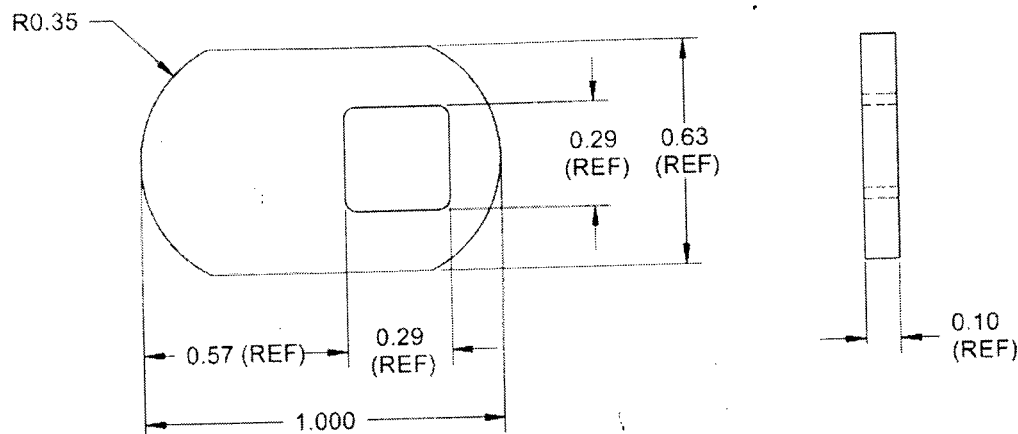
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

& initial all entries



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3371	REV. B SHEET 4 OF 4
DATE 05.03.22		TITLE PEDAL LOCK	SCALE 2:1

SPECIFICATION CONTROL DRAWING



D3371-5 CAM

NOTES:

- 1) MATERIAL: SUPPLIER BY D3373, MODIFIED AS SHOWN
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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Dart Aerospace Ltd

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